

Date: Monday, 5/15/2006 10:44:23 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PILOT/CO-PILOT STEP, RH (FOLDING)
Job Number	: 27089		
Estimate Number	: 12027		
P.O. Number	: N/A	Part Number	: D412630024
This Issue	: 5/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D412-630 REV. J, P13
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26552	Drawing Revision	: J
Written By	: <u>SEE COMMENT BELOW</u>	Material	: PHA
Checked & Approved By	: <u>06.05.15</u>	Due Date	: 6/5/2006
Comment	: Est. Rev B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J LM		

Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-024 CHG002

KS 06-06-01

2.0	D2012107	Clevis
-----	----------	--------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

B25483

3.0	D2803042	Bracket Assembly
-----	----------	------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

B23626 1mcp
 B25918 2mcp B26564 2mcp

4.0	D2804042	Bracket Assembly
-----	----------	------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

B26252

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number: 27089

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Pick:

Qty Part Number

Description

Batch

2 D2807

Gas Spring

B26646

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

B25923

7.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

B26584

8.0

D3388042

Step Weldment RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment RH

B27087

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

M19633

10.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty Part Number

Description

Batch

M100433

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Job Number: 27089

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 AN310C8 Nut

11.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M100695

12.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M19099

13.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

14.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M16984

15.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Job Number: 27089

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M100 680 9 MCP

M100 050 11 MCP

17.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M100 446

P 4/6/23 (5)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.13

S/B 06/06/28 (5)

M.F 06/06/28 (5)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

~~B2655~~ B2655 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Job Number: 27089

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

B26160 ✓

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

B27103 ✓

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

B26771 3mly ✓
B26654 7mly ✓

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C6A

Bolt

M19512 ✓

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M18515 4mly ✓

M100273 1mly ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:44:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 27089

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN4C15A	Bolt

Batch

M100 447 / MCV ✓
M1000036 9 MCV ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description
1	AN44-C7A	Eyebolt

Batch

M19620 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description
2	AN5C15A	Bolt

Batch

M18167 8 MCV M100229 2 MCV ✓

30.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
4	MS21043-4	Nut

Batch

M100 651 ✓

31.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
3	MS21043-5	Nut

Batch

M18535 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PS Date: 06/07/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:44:24 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 27089

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M 100680 ✓

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M100203 30mcx ✓ M19565 5mcx ✓

04/16/22 (5)
04/06/27 (5)
verify code

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-024

Location: A

PPP Rev: A

06/2/4 (5)

H-M 06-07-04

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/05 (5)
06/07/04

Job Completion



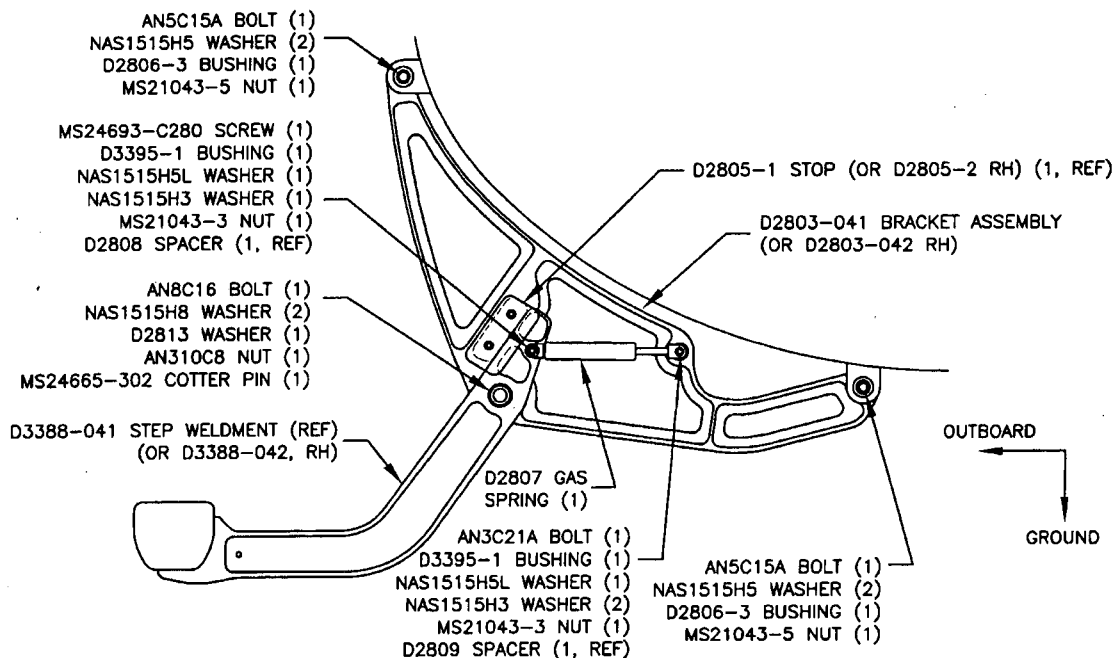
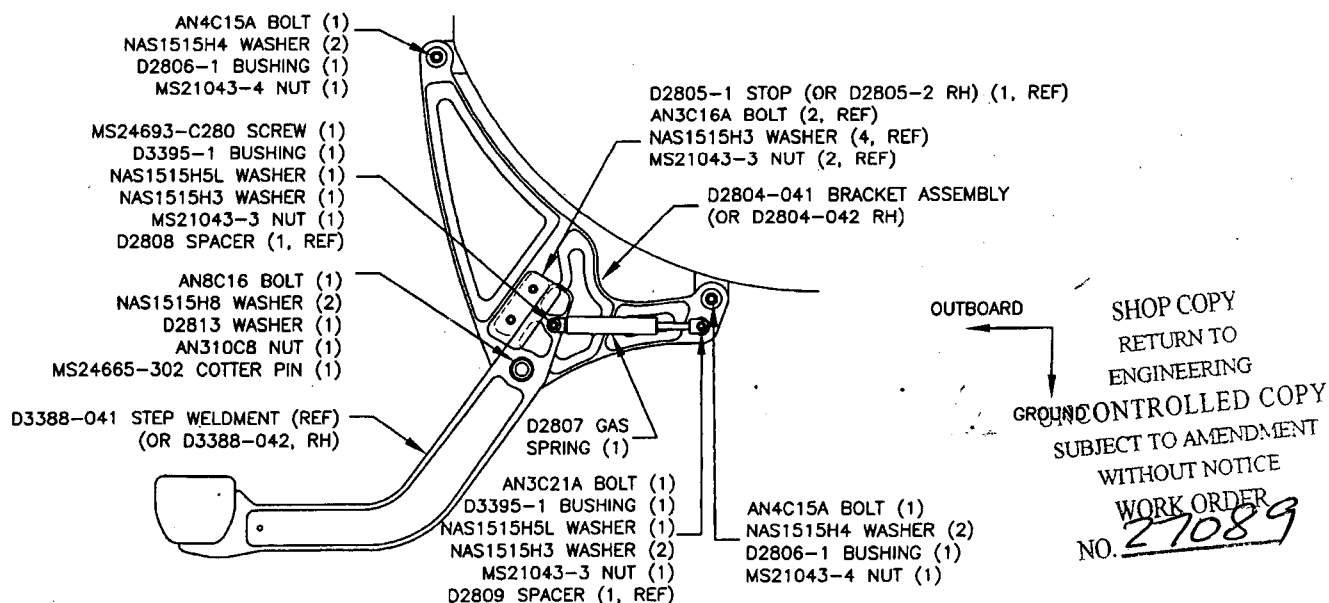
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

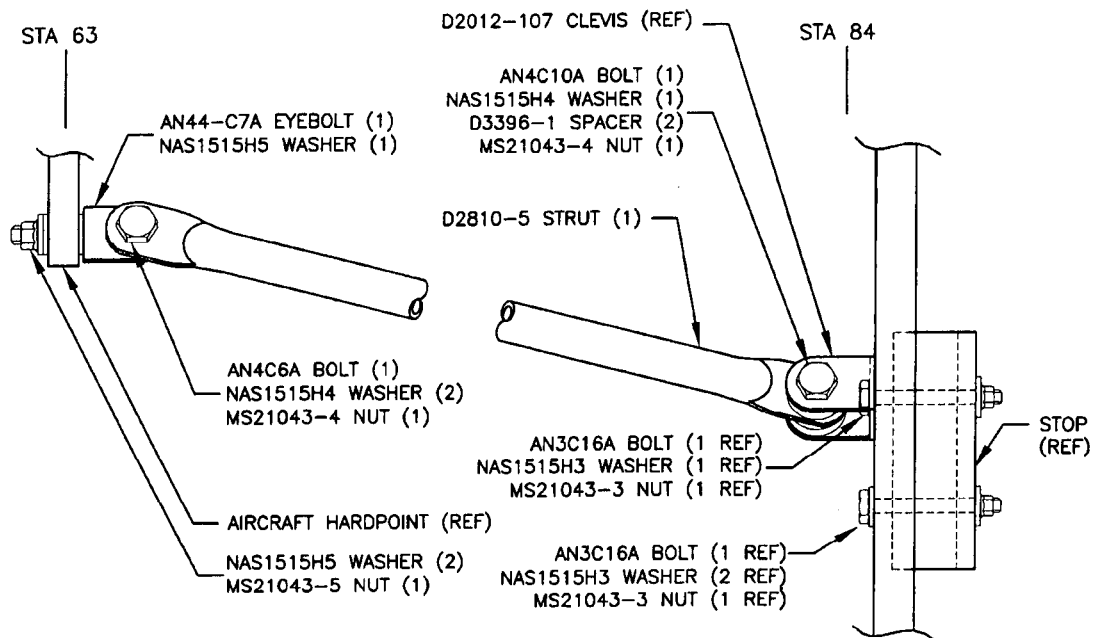
QA: N/C Closed: _____ Date: _____

D412-630-023/-024 Heli-Access-Step™ Installation**FIGURE 11 – STA 84.29 for D412-630-023/-024 Heli-Access-Step™ Installation**
(View rotated 90° CW)**FIGURE 12 – STA 155.06 for D412-630-023/-024 Heli-Access-Step™ Installation**
(View rotated 90° CW)

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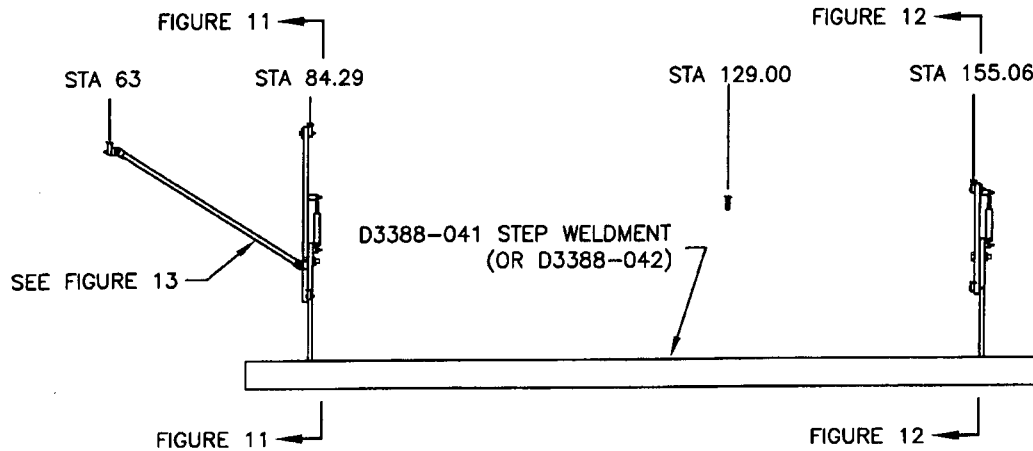
Revision: J
Date: 05.12.08

FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step™* Installation
(NOT TO SCALE)

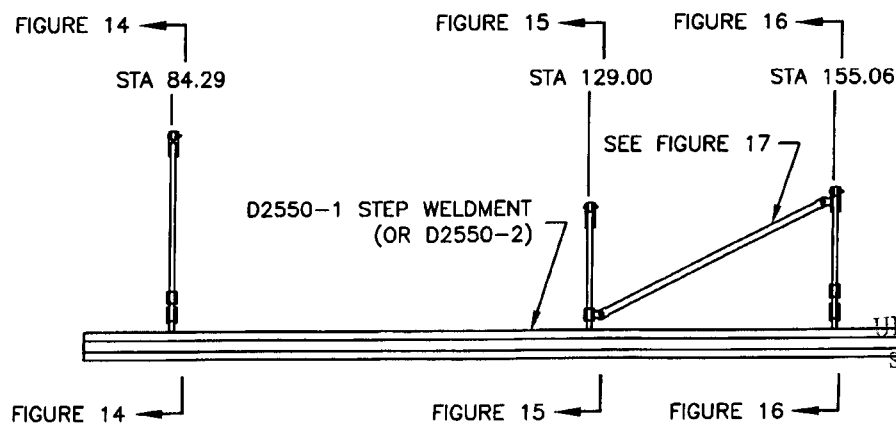


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27089

D412-630-023 HELI-ACCESS-STEP™ LH. FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH. FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH. HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH. HEAVY DUTY FIXED (OPPOSITE)



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27089



FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: J
 Date: 05.12.08

Date: Friday, 12/01/2007 3:00:13 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D412-630 - ECN 903
Job Number : 30251	
Estimate Number : 10804	Part Number : Z_CUSTOM
P.O. Number : N/A	Drawing Number : UPDATE PAPERWORK
This Issue : 12/01/2007 S.O. No. : N/A	Project Number : N/A
Prsht Rev. : NC	Drawing Revision : N/A
First Issue : N/A	Material : N/A
Previous Run : 30247	Due Date : 19/01/2007
Written By : 	Qty: 1 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK
JCAB STC STC-112-2-TYO

D412-630-011 B 1370 2^{ix}, B 20227, 2^x = 3 st x 1
 D412-630-012 B 1370 1^x B 20228 2^x
 D412-630-023 B 26501 1^x B 27271 2^x B 27267 3 B 27088 1^x = 8 st
 D412-630-024 B 28197 2^x B 27089 1^x B 27069 1^x = 4 st
 D412-630-111 B 15054 2^x
 D412-630-112 B 15055 2^x

Signature 07/01/15 07/01/15

2.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/15

Job Completion



u 07-01.15